

2024-T3 Hex 1.375"

Work Order ID 80914

80914

Page 1

March-05-12 10:45:58 AM

Item ID: 41232-200-002-001

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: tube

Stop

NS2

Start Date: 05/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 19/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/05

Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
41232-200-002	Rev A

100

0.00

100

CONVENTIONAL LATHE

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn as per Dwg 41232-200-0021

TURN BORE TAP DRILL 45/64" AND TAP 3/4"20

12-3-15

2

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

12-3-28

2

120

0.00

120

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA687 Rev AA & Dwg 41232-200-002 Rev A

2-Deburr

12-05-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80914

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

2

2

Cust Item ID:

Customer:

Run Start *NR1*

Date:

Date:

Stop ***NR2***

**Insp.
Stamp**

0.00

YL 12-05-03

0.00

Memo

0.00

on 12/05/03

0.00

Memo

0.00

CZ 12/05/03 (2)

Memo

0.00

Issue P/O: 16896 Black Anodize as per Dwg 41232-200-005 Ensure Certificate of Conformity is attached

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80914

80914

Page 3

March-05-12 10:45:58 AM

Item ID: 41232-200-002-001

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: tube

Start Date: 05/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 19/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Receive & Inspect for Damage & Mat'l Certs	0.00							
160									
Packaging	Memo	0.00							
Packaging	Ensure certificate of conformity is attached								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: 364	0.00							
180									
Packaging	Memo	0.00							
Packaging									

Handwritten signature and circled 2

Handwritten circled 2 and date 12-05-10

Handwritten 2 and date 12/5/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80914

80914

Page 4

March-05-12 10:45:58 AM

Item ID: 41232-200-002-001

Accept

Revision ID:

Item Name: tube

Start Date: 05/03/2012 Start Qty: 2.00

2

Required Date: 19/03/2012 Req'd Qty: 2.00

2

Reference:

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____

QC: _____ Date: _____ SPC (Y/N): _____

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/5/15

ME
12-05-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-05-12 10:46:03 AM

Page 1

Work Order ID: 80914

80914

Parent Item: 41232-200-002-001

41232-200-002-001

Parent Item Name: tube

Start Date: 05/03/2012

Required Date: 19/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3H1.375		Purchased	No			100	f	12.0000	0.5	1			

M2024T3H1 375

**

2024-T3 Hex Bar 1.375"

Location

Loc Qty

Loc Code

MAT012

12

120777

12

1 f 12-3-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	80914
Description: Tube		Part Number:	41232-200-002-001
Inspection Dwg: 41232-200-002 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.69	+/-0.030	.69	—		RA26	
4.94	+/-0.030	4.944	—		RA26	
3/4-20	N/A	3/4-20	✓			
R0.44	+/-0.030	.44	✓			
0.61	+/-0.030	.611	✓		HG	
0.88	+/-0.030	.879	✓		RA26	
0.063	+/-0.010	.064	✓		HG	
1.38	+/-0.030	1.374	✓		vern JL-10	
0.69	+/-0.030	.690	✓			
0.12	+/-0.030	.125	✓			
Ø0.12	+/-0.030	.125	✓			
0.98	+/-0.030	.970	✓			
0.25	+/-0.030	.255	✓			
0.36	+/-0.030	.355	✓			
0.37	+/-0.030	.350	✓			
0.10	+/-0.030	.100	✓			
R0.063	+/-0.010	.063	✓		R-G	
0.373	+0.017/-0.000	.375	✓		vern JL-10	
Ø0.34	+/-0.030	.342	✓		"	
R0.25	+/-0.030	.25	✓		R-G	
2.38	+/-0.030	2.381	✓		vern JL-10	
3.81	+/-0.030	3.810	✓		HG	

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 12-3-27	Date: 12/05/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.12.02	New Issue	KJ/DD	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

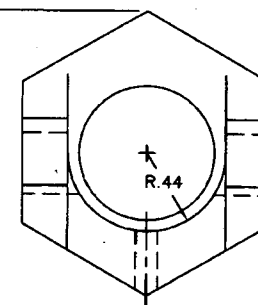
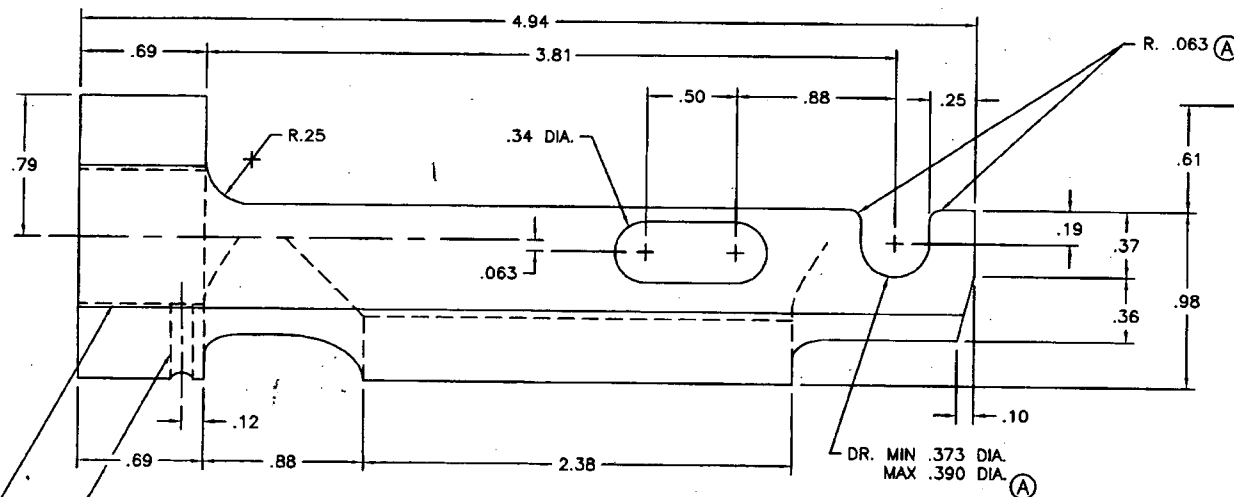
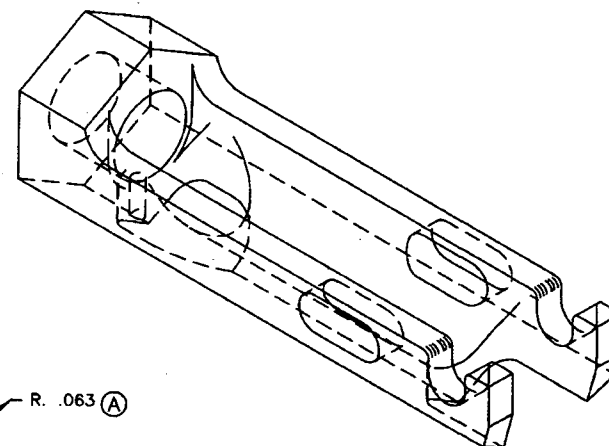
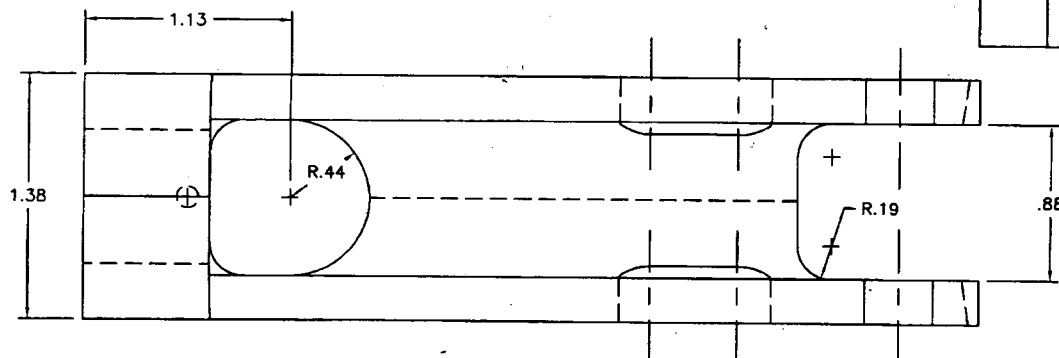
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REVISION					
LETTER	DFTSMAN	DATE	DESCRIPTION	APPROVED	DATE
A	DNN	2/17/03	ADDED SMOOTH EDGES TO -001 & -003; REDUCED LENGTH OF -003 BY .125"; ADDED DRAIN HOLE TO -001; INCREASED DIA. OF AFT SLOT ON -001.		
			MINOR CHANGE - FAR 21.95	CHECK D. MURPHY	2/17/03



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 80917





MLJ
12/03/05

- DR. .12 DIA. DRAIN HOLE
(NOTE: SPOTFACE IF REQ'D (A)
TO DRILL HOLE)

- 3/4"-20 THD.

① ANODIZE IN ACCORDANCE WITH MIL-A-8625, TYPE III, CLASS 2 DYED BLACK.

NOTE:

1	MS21209F4-15	INSERT				
	-005	PIVOT ARM 	1.00 DIA. x 3.56	2024-T4, T351 ALUM.		
	-003	LATCH 	1.11 x 3.50	2024-T4, T351 ALUM.		
	-001	TUBE 	1.38 HEX STK. x 4.94	2024-T4, T351 ALUM.		
-005	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE
NO. REQ'D PER ASSY		LIST OF MATERIAL				
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			CHECK	D. MURPHY	2/18/02	
			STRESS			
			PROJ. ENGR.			
			HEAT TREAT			
2 41232-200-001			DWG. SIZE C		SCALE 2:1	
NEXT ASSEMBLY		FINISH 	Era Aviation, Inc.			DWG. NO. 41232-200-002 SHT 1 OF 3
						REV. A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

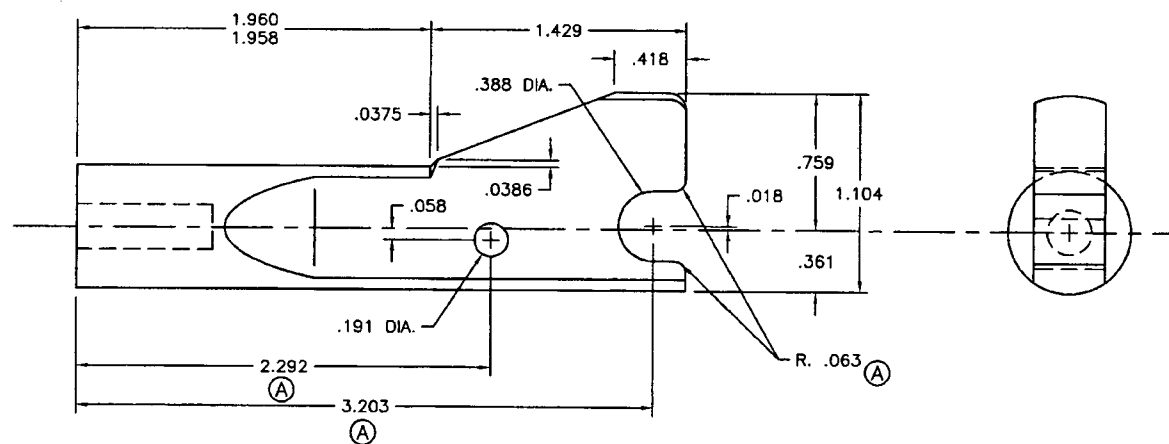
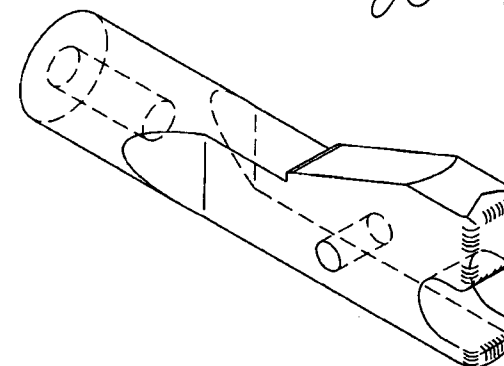
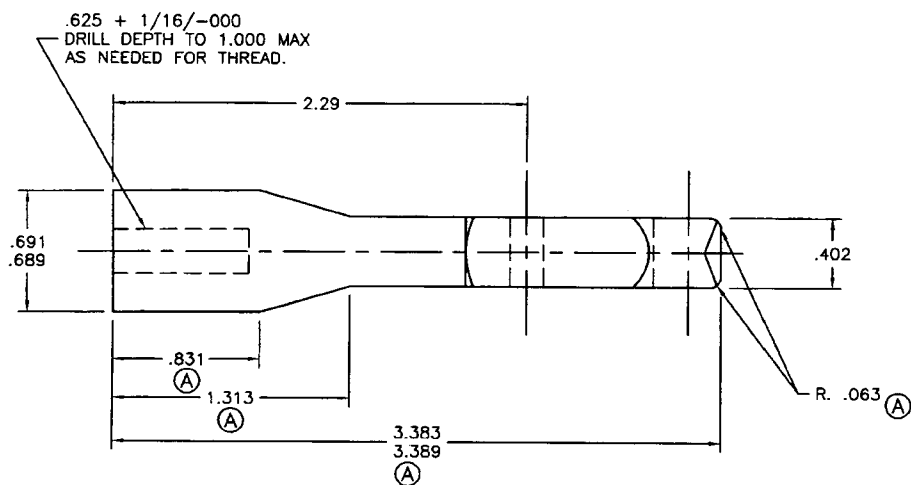
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80914



-003 LATCH

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Era Aviation, Inc.

STEP ACTUATOR COMPONENTS

C

DRG. NO.

41232-200-002
SHT 2 OF 3

REV.
A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

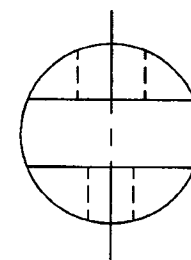
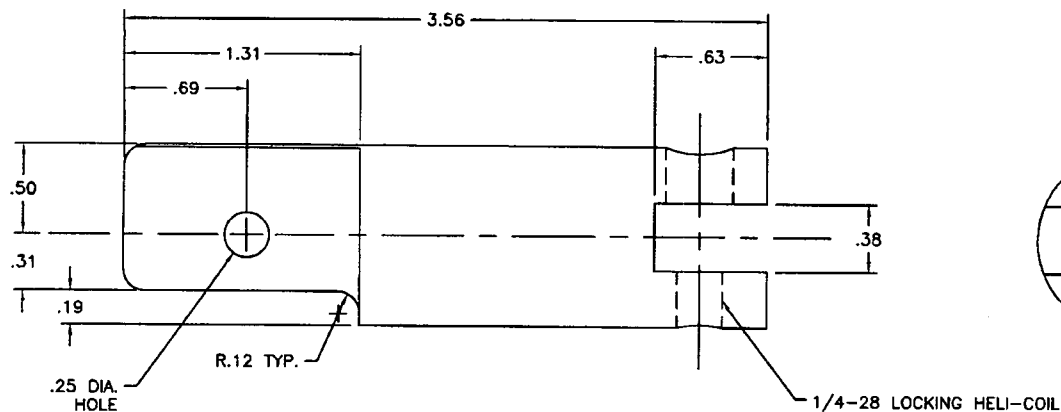
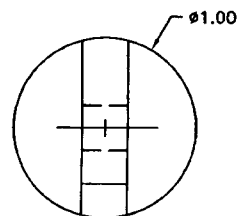
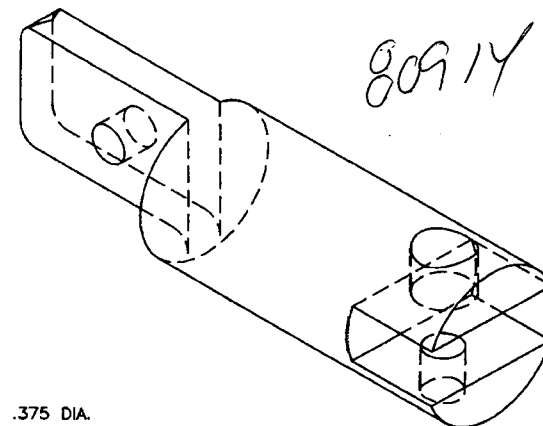
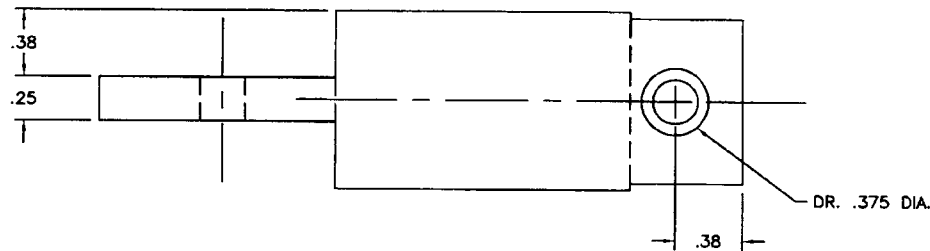
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80914



-005 PIVOT ARM

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Era Aviation, Inc.

TITLE
STEP ACTUATOR COMPONENTS

SIZE
C

DWG. NO.
41232-200-002
SHT 3 OF 3

REV.
A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DATE 2/26/04	ENGINEERING ORDER	E.O. No. B-1	SHT. 1 OF 1
BY D. NELSON		DWG. AFFECTED 41232-200-002	
APPROVED BY		SHEET AFFECTED SHT 1 & 3	
TITLE STEP ACTUATOR COMPONENTS			

REASON FOR CHANGE: CHANGED DASH NO. OF INSERT ON L/M; CHANGED INSERT CALLOUT ON -005 PIVOT ARM.

MINOR CHANGE - FAR 21.95

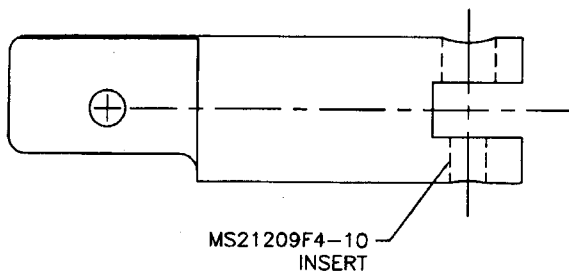
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WAS

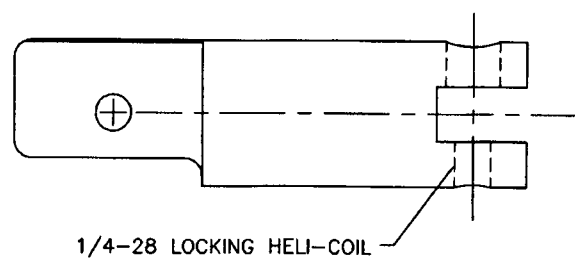
1	MS21209F4-15	INSERT
---	--------------	--------

IS



-005 PIVOT ARM

WAS



-005 PIVOT ARM

60914

CHANGE REQUIRED:	DATE:	BY:	YES	NO
TRAVELER				
INSTALLATION INSTRUCTIONS				
MAINTENANCE INSTRUCTIONS				
ILLUSTRATED PARTS				
UNINCORPORATED DRAWING LIST				
MASTER DRAWING LIST				
COMPUTER DATA BASE				

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO16896

Purchase Order Date 5/03/12

PO Print Date 5/03/12

Page Number 1 of 1

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKALND, ON K4K 1T2
CANADA

Contact Name

Vendor Phone

613-446-4544

Vendor Fax

613-446-4556

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	80914	D41232-200-002-001 TUBE	5/03/12 Yes	2.00		\$45.0000	\$90.00

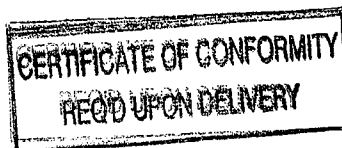
Special Inst:

ANODIZE AS PER DWG 41232-200-002-001
BALCK ANODIZE AS PER MIL-A-8625F
TYPE II
IB/IC/II OR IIB CLASS2

PO Total:

\$90.00

B 80914



Change Nbr:

1

Change Date: 5/03/12

No substitution or deviation without consent.
Certificate of Conformity or Material Certification required when applicable



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 61717

Date: 07-May-12

To

DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
CANADA

Ship To


DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
CANADA

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
2 ea	Part: D41232-200-002-001 TUBE Rev: BLACK ANODIZE MIL-A-8625 TYPE 2 CLASS 2 Job: 20120292 PO: PO16896 Line:		
<p>Certificate of Conformance</p> <p>A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.</p> <p>ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY</p> <p>DATE : <u>7/5/12</u></p> <p>CERTIFIED SIGNATURE : <u></u></p> <p>RECEIVER SIGNATURE : _____</p>			